

Date: Thursday, 23/04/2009 7:50:42 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SEAT BELT GUIDE ASSEMBLY
Job Number	: 47237		
Estimate Number	: 13859		
P.O. Number	:	Part Number	: D3920041
This Issue	: 23/04/2009 S.O. No. :	Drawing Number	: D3920 PREL
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 16/04/2009 Type : MACHINED PARTS	Drawing Revision	: PREL
Previous Run	: 47223	Material	:
Written By	: <u>JLM 09.04.22</u>	Due Date	: 22/04/2009 Qty: 4 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 09-04-15 JLM Verified By:EC		

Additional Product

Job Number:



PRELIMINARY ISSUE

Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0750X01000 6061-T6 Bar .750 x 1.00



Comment: Qty.: 0.7875 f(s)/Unit Total : 3.1500 f(s)

6061-T6 Bar .750 x 1.00

BATCH: M104186. M1587 1pc.
JLM 09.04.22 (4)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 9.25" long

JLM 09.04.22 (4)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA811 Rev: AA & Dwg D3920 Rev: PREL
09/04/23 (3)

2-Deburr per dwg D3920

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/04/23 (3)

5.0 QC8 SECOND CHECK ENGINEERING APPROVAL



Comment: SECOND CHECK

ASS 09.04.02
JLM 09.04.23 (3)
P+0  
→

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 2 Date: 09/04/23

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/23	3.0	Work off center of piece. Origin off. R.C. Operator error training 1 part scrap <u>1st op</u>		Scrap and replace 1 pc. M1587 1 pc.	<u>✓</u> 09/04/23	<u>8/8</u> 09/04/23		
09/04/23	3.0	1 part scrap Work piece moved in vice, jig fixture Problem. Remachined jig. R.C. Jig fixture <u>2nd op</u>		Scrap don't replace 1 pc	<u>✓</u> 09/04/23	<u>8/8</u> 09/04/23		

NOTE: Date & initial all entries

Date: Thursday, 23/04/2009 7:50:42 AM  
User: Jean-Luc Menard

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BELT GUIDE ASSEMBLY

Job Number: 47237

Part Number: D3920041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 D39203 Seatbelt Guide Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Seatbelt Guide Bracket  
BATCH: B47354

*PL 09.04.24 3*

7.0 D39207 Seatbelt Guide Shim



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Seatbelt Guide Shim B47386

*PL 09.04.24 3*

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
1-Chamfer end as per DwG d3920

2-Weld assembly as per dwg D3920 & QSI 004

AL ROD A/R BATCH: M110130

**ENGINEERING  
APPROVAL**

9.0 QC9 VISUAL WELDING INSPECTION



*QC5 - 20.04.24*

Comment: VISUAL WELDING INSPECTION

*QC9 - PD 09.04.24*

*Sort 04/24 (13)*

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*(M10)*

*(13) 09/04/24*

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*M109091*

START TIME: *10:15*

OVEN TEMPERATURE: *320°*

FINISH TIME: *10:45*

*BR 09-04-24*

*(3)*

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BELT GUIDE ASSEMBLY

Job Number: 47237

Part Number: D3920041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*09/04/24 (3)*

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*09/04/22 (3)*

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(3)*  
*09/04/24*

Job Completion



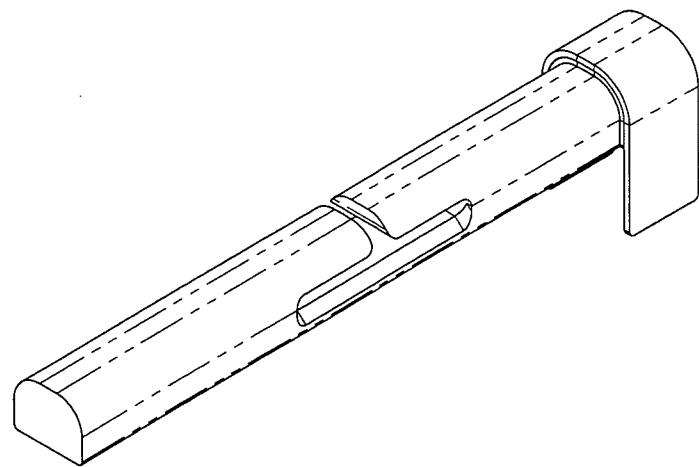
POSITIVE RECALL

EFFECTIVE *09-04-24* AUTH *W*

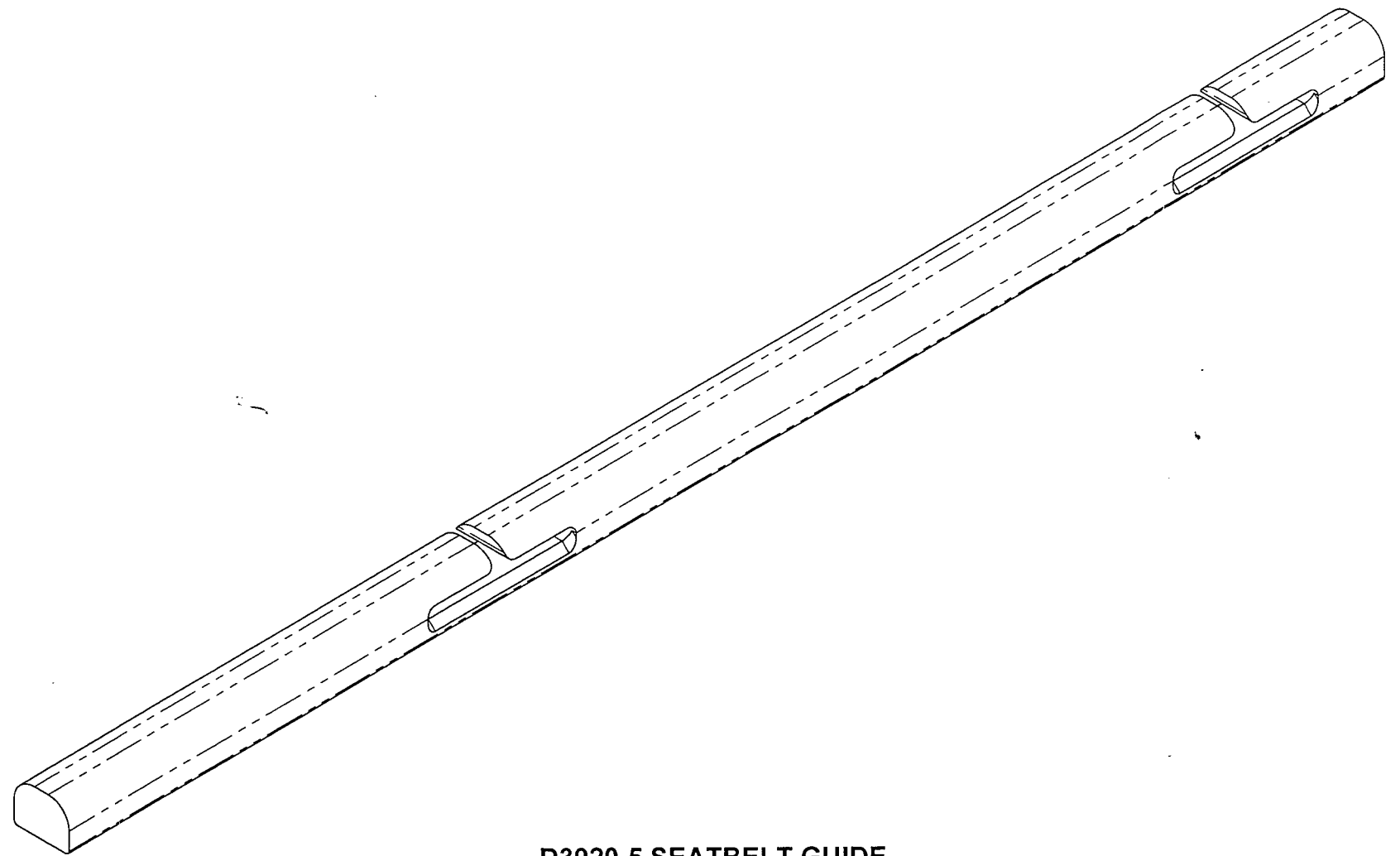
RELEASED *ISS* DATE *09-04-24*

*MF 09-04-24*





**D3920-041 SEATBELT GUIDE ASSEMBLY**



**D3920-5 SEATBELT GUIDE**

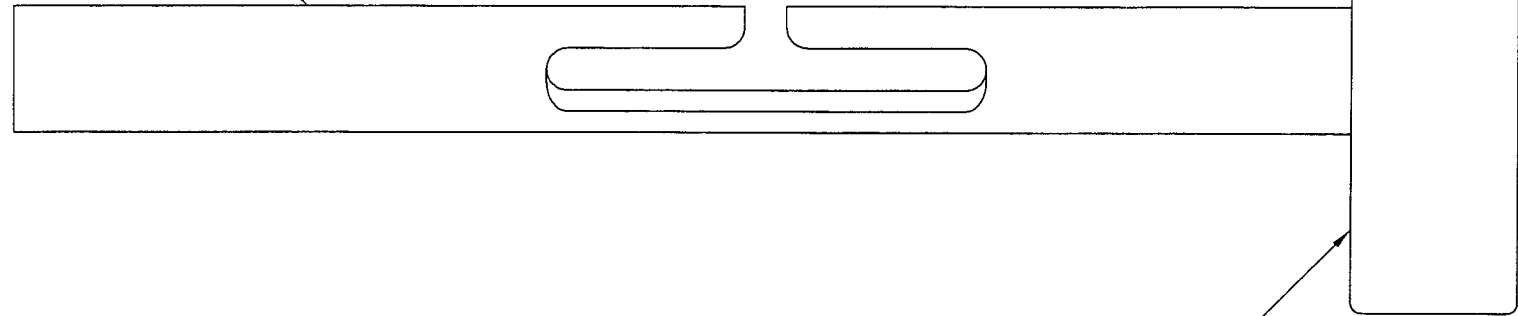
47237

**PRELIMINARY  
ISSUE**  
AJS 09.04.22

B	ADD -7 TO -041 ASSEMBLY UPDATED DIMENSIONS FOR -3 ACCORDINGLY. SEE PAR 09-014.	AJS	09.04.22
A	NEW ISSUE	AJS	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3920	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SEATBELT GUIDE ASSY (214B/B1)	NTS
DATE	09.04.22	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

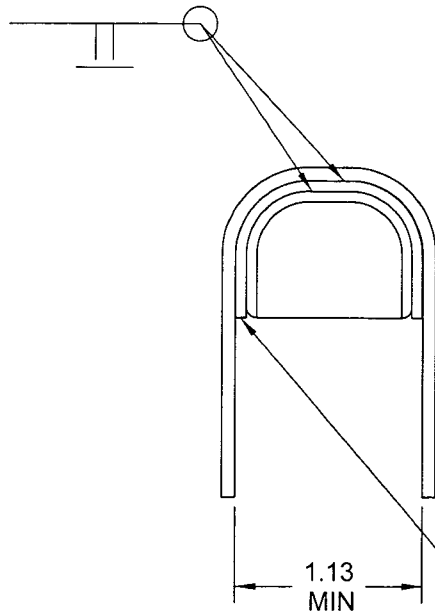
ITEM No.	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3920-041	SEATBELT GUIDE ASSEMBLY
9	1	D3920-1	SEAT BELT GUIDE
10	1	D3920-3	SEAT BELT GUIDE BRAK CET
11	1	D3920-7	SEAT BELT GUIDE SHIM

D3920-1  
SEAT BELT GUIDE



D3920-3  
SEATBELT GUIDE BRACKET  
(ASSEMBLE AT  
CHAMFERED END)

**D3920-041 SEATBELT GUIDE ASSEMBLY**



△B  
D3920-7  
SEATBELT GUIDE BRACKET  
(ASSEMBLE AT  
CHAMFERED END)

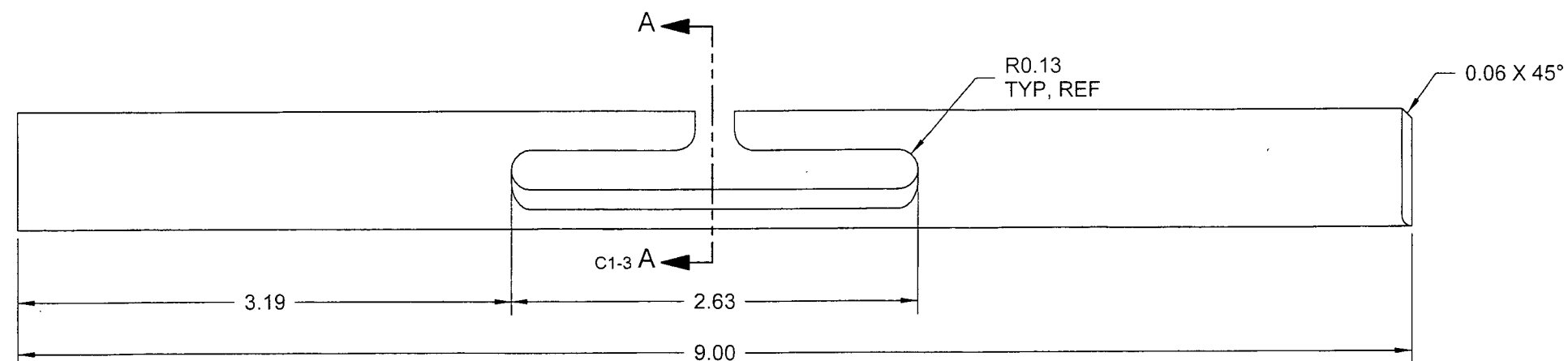
47237

**NOTES: D3920-041**

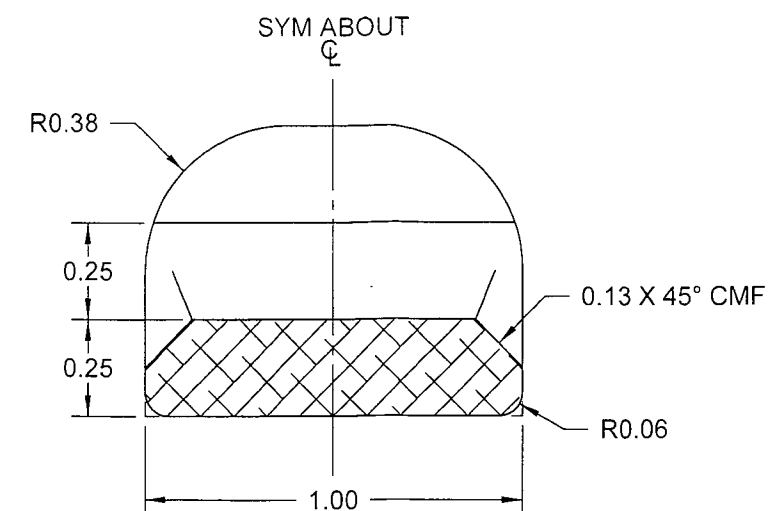
- 1) MATERIAL:
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3920-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.58 lbs

**PRELIMINARY  
ISSUE**  
DJS 09.04.22

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. <b>D3920</b>	REV. B
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE <b>SEATBELT GUIDE ASSY (214B/B1)</b>	SCALE NTS
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.04.22		

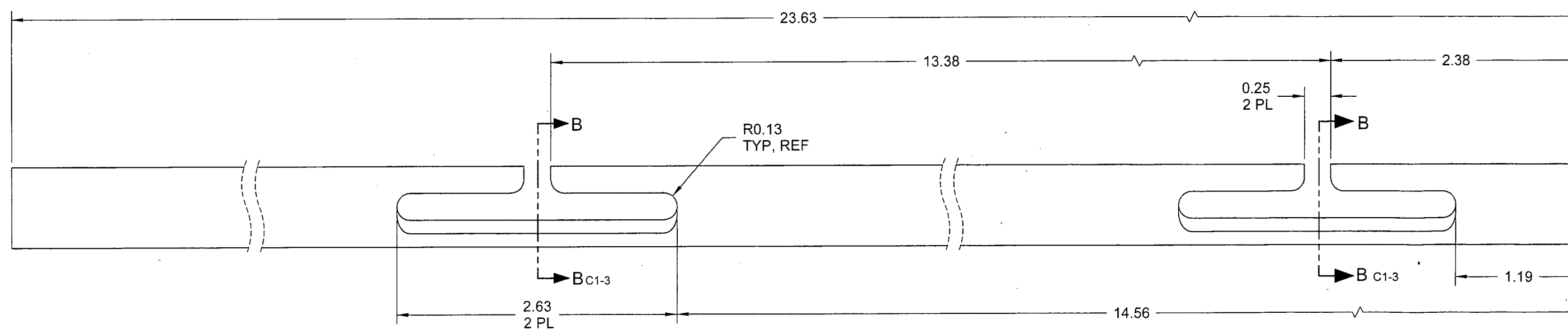


## D3920-1 SEATBELT GUIDE



**SECTION A-A** C6-3  
SCALE 2X

**SECTION B-B** B2-3  
SCALE 2X B5-3





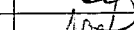
## D3920-5 SEATBELT GUIDE

NOTES: D3920-1&-5

1) MATERIAL: 6061-T6 (OR T651/T6510/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS4160)  
REF DART SPEC M6061T6B

2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT -1: 0.53 lbs  
              -5: 1.44 lbs

PRELIMINARY  
ISSUE  
4/509.06.22

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D3920 SHEET 3 OF 3
APPROVED		TITLE SCALE
DE APPR.		SEATBELT GUIDE ASSY (214B/B1) NTS
DATE	09.04.22	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

47237

A



ITEM No.	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3920-041	SEATBELT GUIDE ASSEMBLY
9	1	D3920-1	SEAT BELT GUIDE
10	1	D3920-3	SEAT BELT GUIDE BRACKET
11	1	D3920-7	SEAT BELT GUIDE SHIM

D3920-1  
SEAT BELT GUIDE

D3920-3  
SEATBELT GUIDE BRACKET  
(ASSEMBLE AT  
CHAMFERED END)

D3920-7  
SEATBELT GUIDE SHIM  
(ASSEMBLE AT  
CHAMFERED END)

# **D3920-041 SEATBELT GUIDE ASSEMBLY**

## **NOTES: D3920-041**

- 1) MATERIAL:
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3920-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.58 lbs
- 8) WELDING: PER DART QSI 004

**RELEASED**  
09/04/22

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3920	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SEATBELT GUIDE ASSY (214B/B1)	NTS
DATE	09.04.22	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	